

Work Order ID 79176

January-23-12 10:45:24 AM

79176

Page 1

Item ID: D4407-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 23/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLT

Date: 12/01/23

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4407

A

100

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

1-mill as per Dwg D4407

2-Deburr if necessary

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 12/14

0.00

150

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

H.C.J. 12/02/03



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Picklist Print

January-23-12 10:45:28 AM

Page 1

Work Order ID: 79176

79176

Parent Item: D4407-1

D4407-1

Parent Item Name: Bar

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	476.7797	5.66	23.83158			

M304B0 250x0 500

**

304 BAR .250 x .500

Location	Loc Qty	Loc Code
MAT006	175.212	
117842	8.3	
119050	21.67	
119159	145.242	
MAT050	301.5677	
117176	37.8947	
119872	263.673	

M 304 .250 x .500

M 120488

24 f. 12/02/01

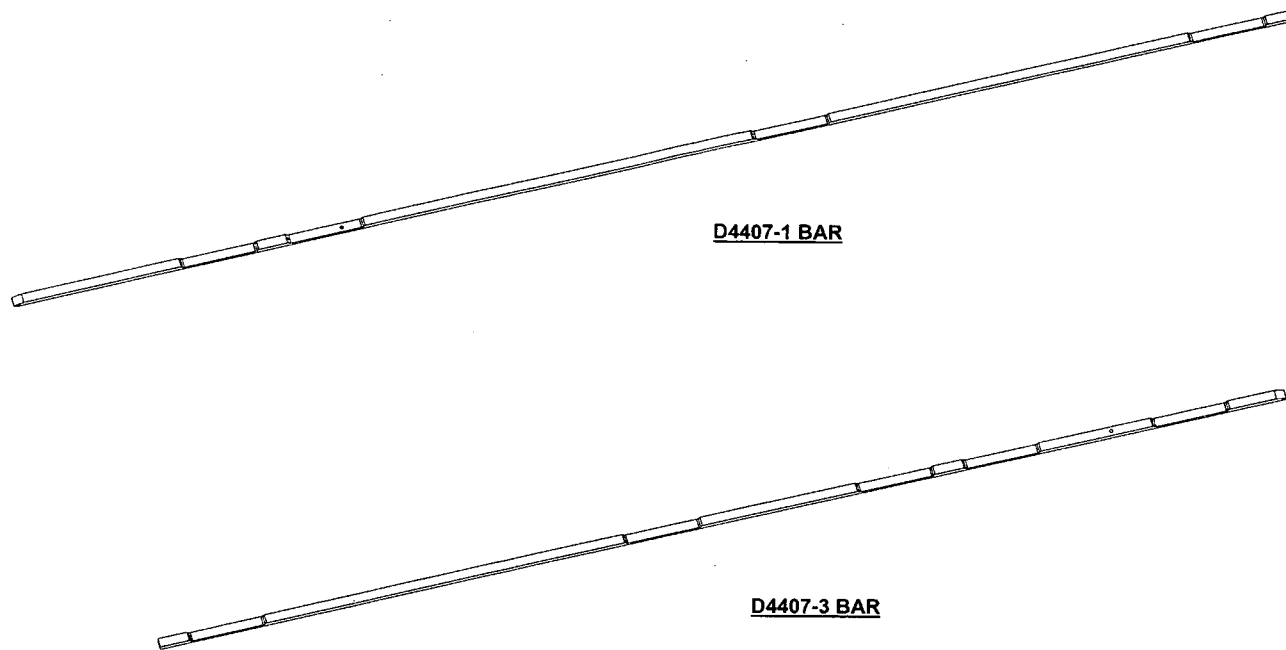
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NOTE: Date & initial all entries



D4407-1 BAR

D4407-3 BAR

RELEASE
R 2011-08-29
MP

UNCONTROLLED
SUBJECT TO
WORK

NO. 79176 M.L.J
12/01/23

A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	DS	D4407	SHEET 1 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BAR	NTS
DATE	11.08.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

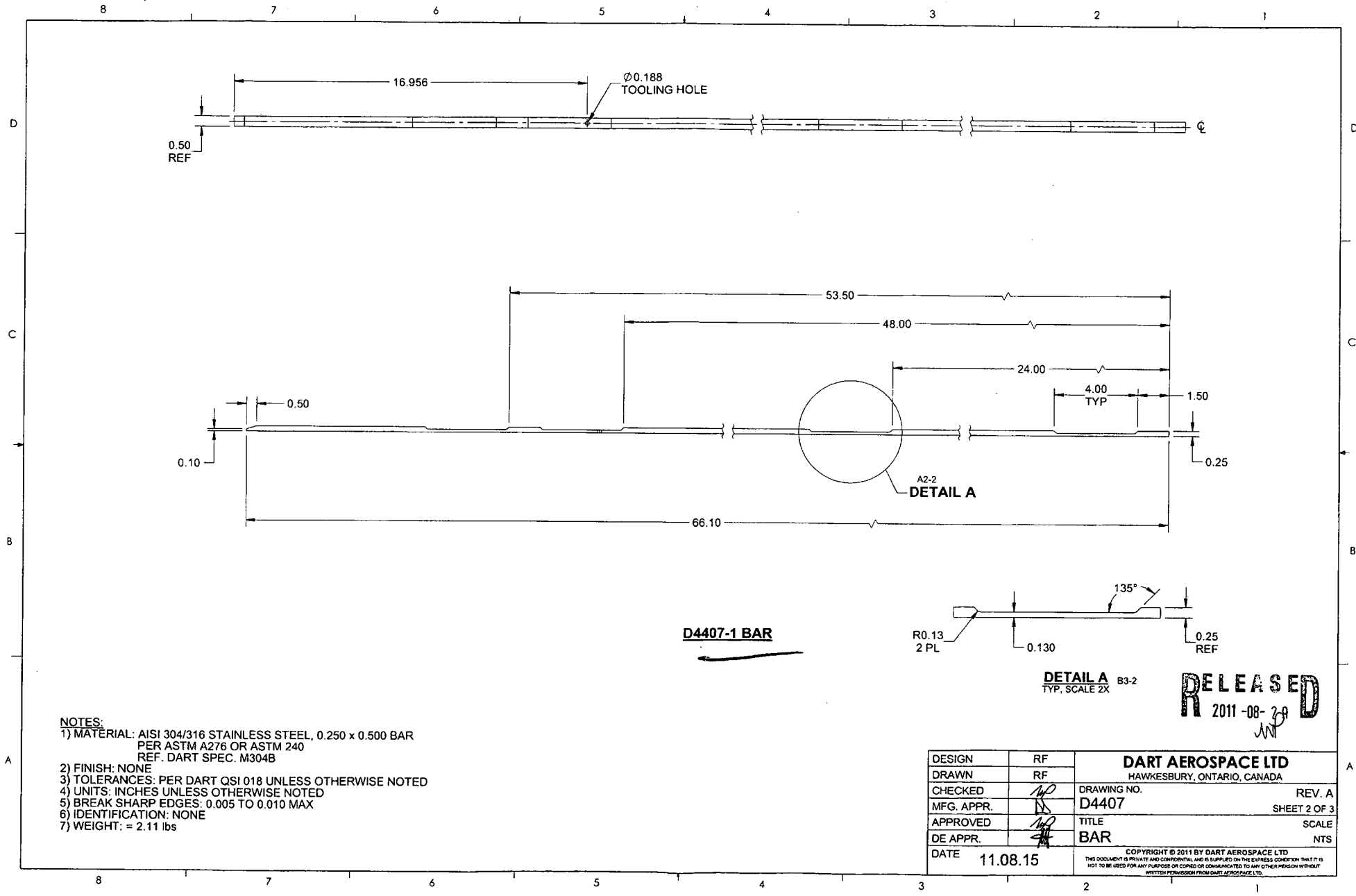
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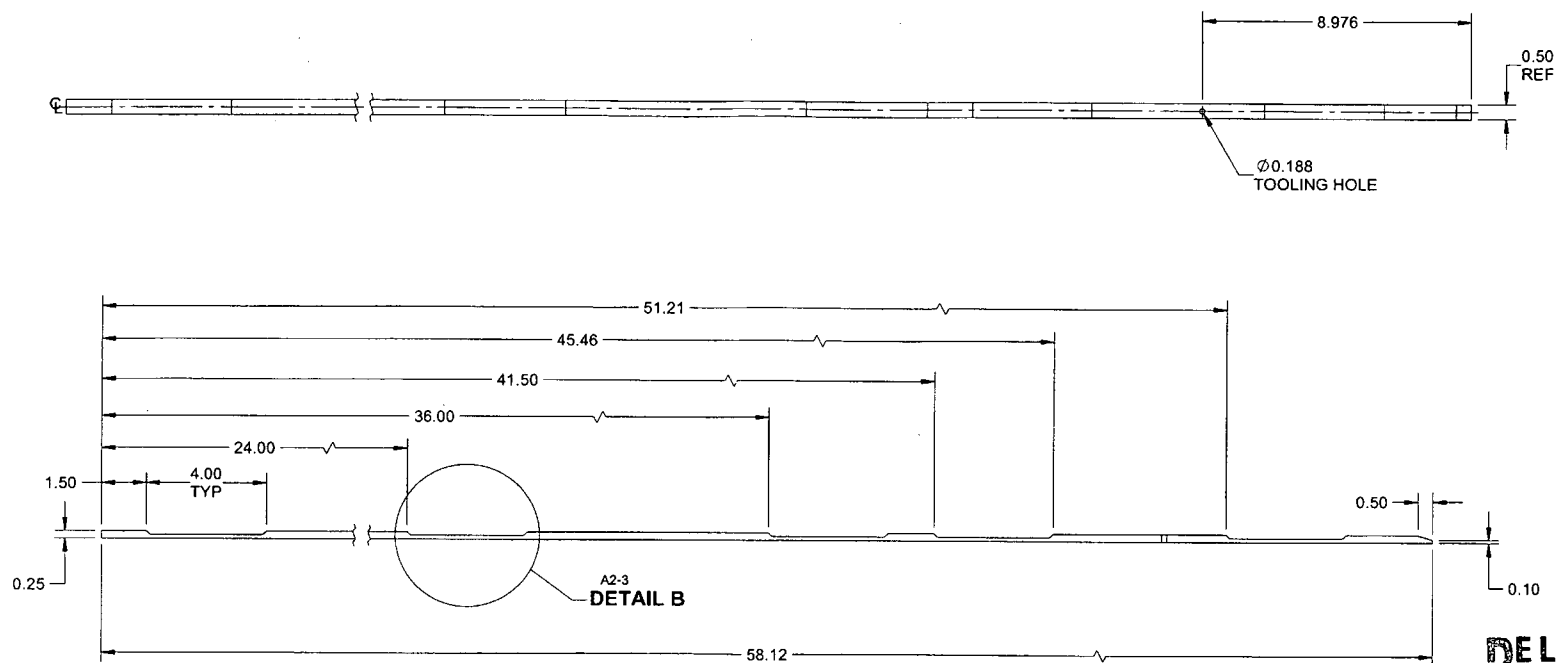
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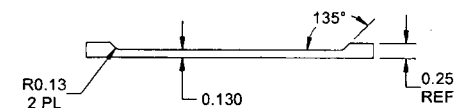
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79176



D4407-3 BAR



DETAIL B B5-3
TYP, SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 1.76 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4407	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
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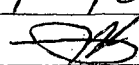

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Work Order: 79176	Part Number: 4407-1	Inspection Dwg: 4407	Rev: A
Description: 13AR		Page 1 of 1	

☒ First Article
 ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Dimension	Accept	Reject	Method of Inspection	Comments
1.50	±.030	1.50	—	—	—	—	RA04	TAP
4.00	±.030	4.00	—	—	—	—	"	
24.00	±.050	24.00	—	—	—	—	"	
48.00	±.050	48.00	—	—	—	—	"	
53.50	±.030	53.50	—	—	—	—	"	
66.10	±.030	66.120	—	—	—	—	RA04	TAP
1.50	±.030	1.50	—	—	—	—	RA04	TAPS
.10	±.030	.110	—	—	—	—	RA26	vern
.130	±.010	.127	—	—	—	—	RA26	vern

Measured by: 	Date: 12/02/01	Audited by: 	Date: 12/02/01	Prototype Approval: _____	Date: _____
Rev	Date	Change	Revised by	Approved	New Issue